

Work Order ID 73323

Wednesday, August 31, 2011 10:58:37 AM

Page 1

Item ID: D3564-13

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 9/1/2011 Start Qty: 16.00

Required Date: 9/15/2011 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: MF Date: 11-09-01

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3564	Rev D

100 0.00



Waterjet
FLOW CNC Waterjet
304 .063

FLOW WATER JET

Memo
1-Cut as per Dwg D3564 11 Dwg Rev: D 12-
Deburr if necessary

Bit 9-13

(18)

110 0.00



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

Bit 9-13

120 0.00



QC
Quality Control

QC8- Inspect parts - second check

Memo

8/31/11

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 73323

Wednesday, August 31, 2011 10:58:38 AM

Page 2

Item ID:	D3564-13	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	9/1/2011	Start Qty:	16.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	16.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				<u>18</u>			
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary <input type="checkbox"/> Form on Brake as per Dwg D3564 using Jigs DT 8179								
140  QC	QC5- Inspect part completeness to step on W/O	0.00				<u>268</u>			
QC	Memo	0.00							
Quality Control									
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	START TIME: <u>1:00</u>								
	FINISH TIME: <u>3:30</u>								

M117338

3200F

T=30

18X Ø M-L 11/04/20

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3564-13

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/1/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 16.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

F-P 2

18 X Ø M 11/09/20

18 X Ø M 11/09/20

11/9/21

ME 11-09-21

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, August 31, 2011 10:58:34 AM

Page 1

Work Order ID: 73323



Parent Item: D3564-13



Parent Item Name: Wearshoe

Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44657 09-02-04 KJ
Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	129.1000	0.222	3.738947	4,		



304/316 Sheet .063



B11-9-B

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

118578

(18)

W/O:		WORK ORDER CHANGES					
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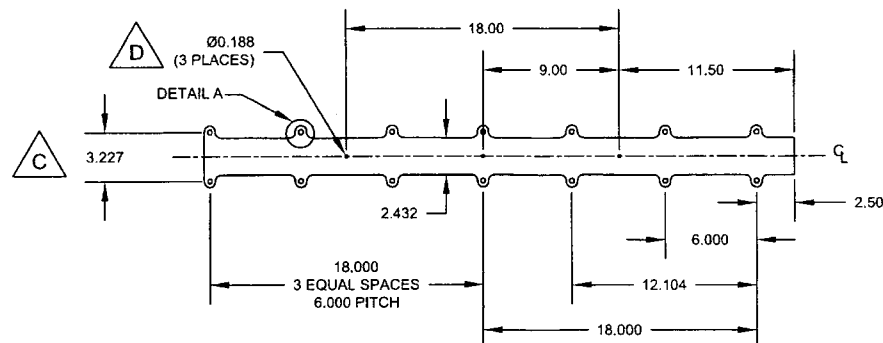
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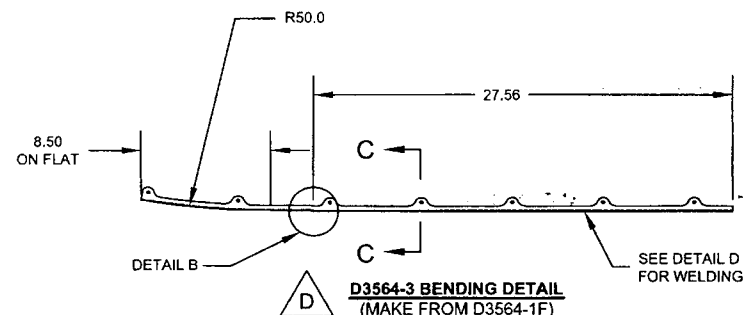
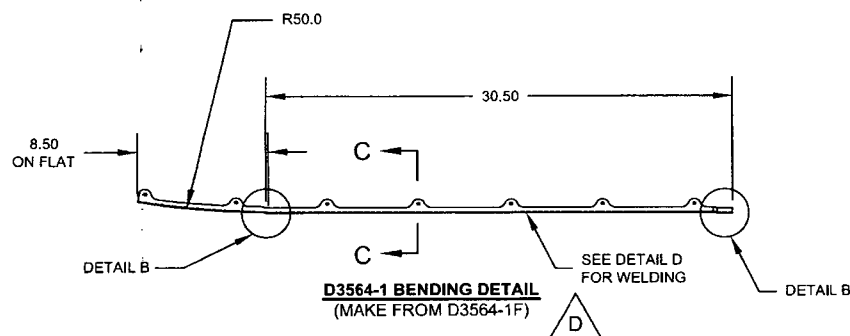
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D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT ϕ

73323

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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RELEASED

07.09.04

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D3564-5F FLAT PATTERN

D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-7F FLAT PATTERN

D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SA	D3564	SHEET 2 OF 3
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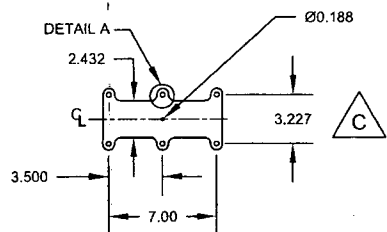
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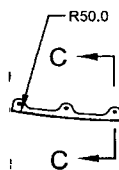
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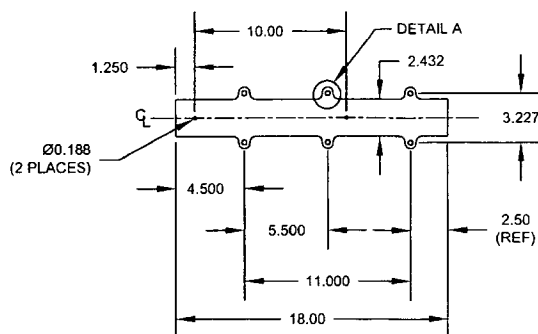
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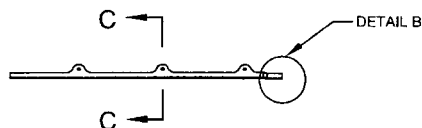
D3564-13F FLAT PATTERN



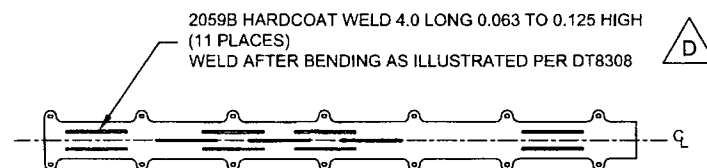
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



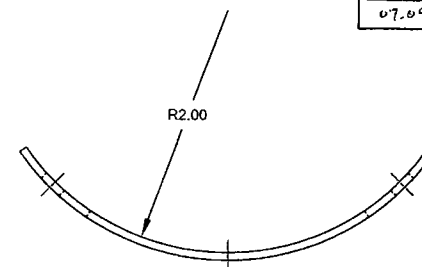
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



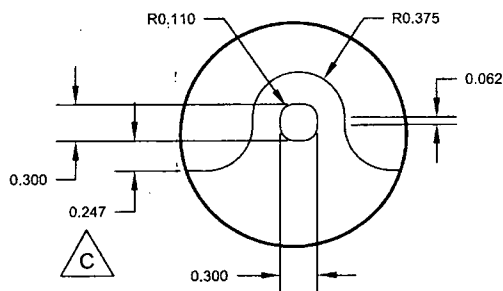
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

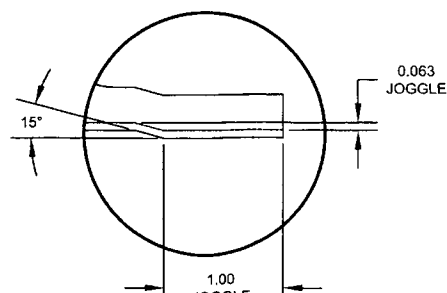
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SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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DRAWN	CS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
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